

Date: Monday, 18/08/2008 10:26:49 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET BASE ASSEMBLY		
Job Number	: 41286B			Part Number	: D3324041		
Estimate Number	: 10852			Drawing Number	: D3324 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/08/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 08/09/2008 Qty: 1 Um: Each		
Previous Run	: 41171B						
Written By	:						
Checked & Approved By	: <u>JUL 08-8-18</u>						
Comment	: Est Rev:A 05.02.09 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33283	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	<i>PCL 08-09-11</i>
		Pick:	
		Qty Part Number Description Batch	
	2	D3328-3 Hinge Plate	<u>333872</u>
2.0	D33481	Clevis	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	<i>PCL 08-09-11</i>
		Pick:	
		Qty Part Number Description Batch	
	4	D3348-1 Clevis	<u>341178</u>
3.0	D33493	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	<i>PCL 08-09-11</i>
		Pick:	
		Qty Part Number Description Batch	
	2	D3349-3 Spacer Bushing	<u>338178</u>
4.0	D33671	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	<i>PCL 08-09-11</i>
		Pick:	
		Qty Part Number Description Batch	
	2	D3367-1 Mounting Bracket	<u>340775</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41286B		Part Number: D3324041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	M4130NTS0500W035	4130 Square tube .500 x .500 x .035w 
Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s) Material: 4130 Cond. N Square tube per MIL-T-6736, 1/2" x 0.035" wall M4130N-TS0.500W.035)		 <i>P 08-09-11</i>
6.0	M569EX05018F	569 Expanded Metal 
Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s) Pick: Qty Part Number Description Batch 28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel M107677 		<i>P 08-09-11</i>
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 1-Cut tubes as per Dwg D3324 Qty Part Number Description Batch 3 D3324-1 Bottom Tube 4 D3324-3 Full Length Tube 2 D3324-5 Top End Tube 2 D3324-7 Bottom EndTube 10 D3324-9 Vertical Tube Identify parts appropriately 2-Remove all markings from material & check for foreign objects 3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B A/R4130 Steel Rod <i>M102224</i> 4-Deburr as required 		<i>P 08-09-11</i>
8.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<i>P 08-09-11</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3324041

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 080811 80

10.0 POWDER COATING

POWDER COATING



1108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

11:45pm

OVEN TEMPERATURE:

4000F

FINISH TIME:

12:15pm

2ND COAT:

START TIME:

12:50pm

OVEN TEMPERATURE:

400F

FINISH TIME:

1:20pm

08-08-11 (X)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E 08/09/12 0

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6-A

E 08/09/12 0

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/12 (X)

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-09-12

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

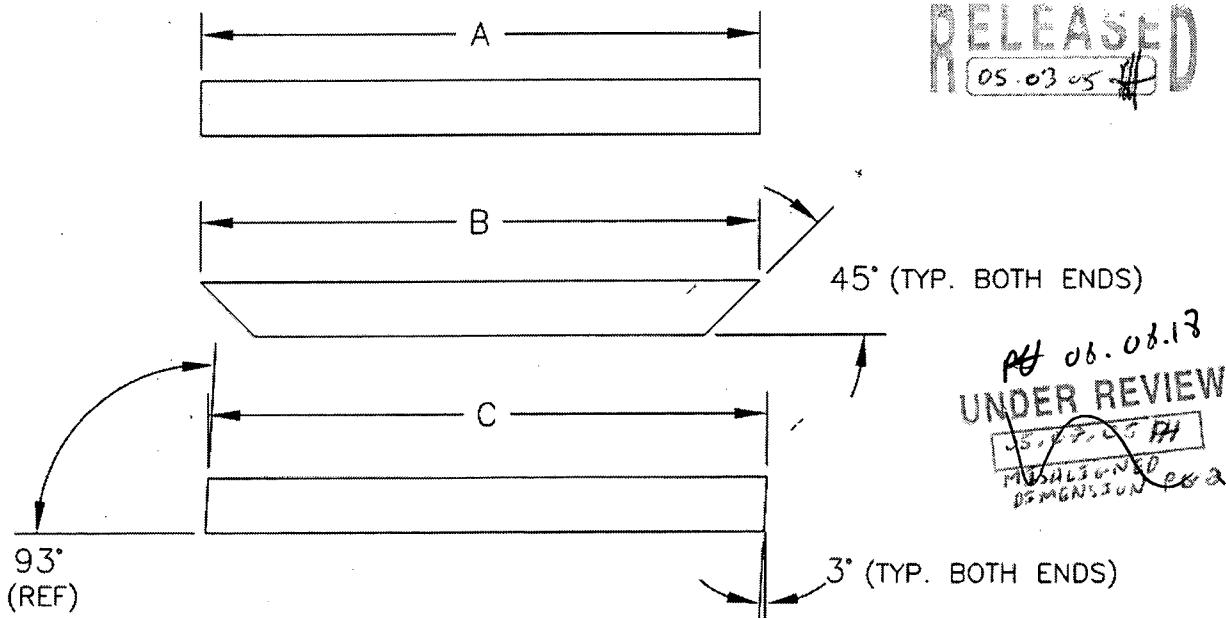
NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3324	REV. B	SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS	
	A 04.10.20	NEW ISSUE		
	B 05.03.04	UPDATE MESH MATERIAL SPEC		

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 INCHES
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 41286B

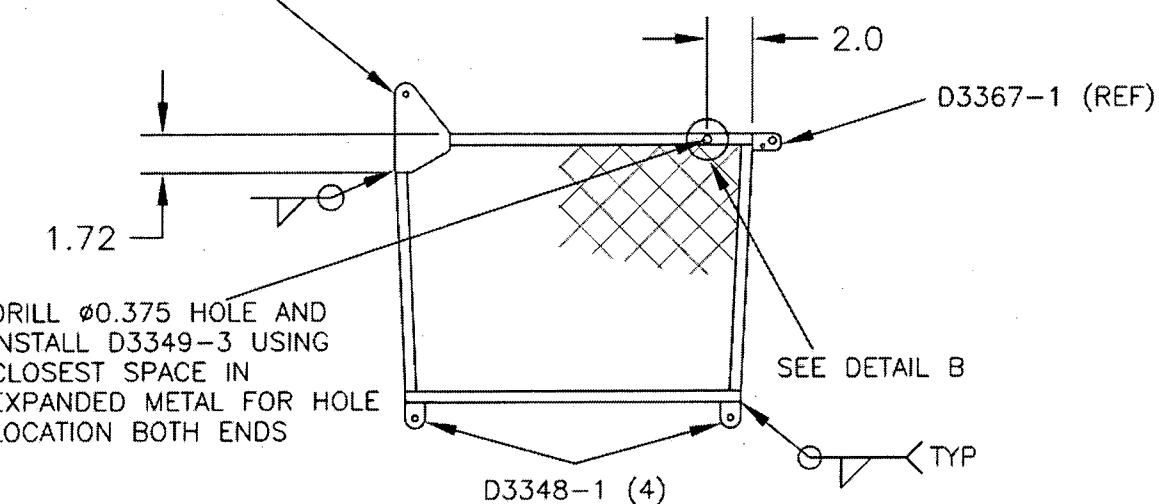
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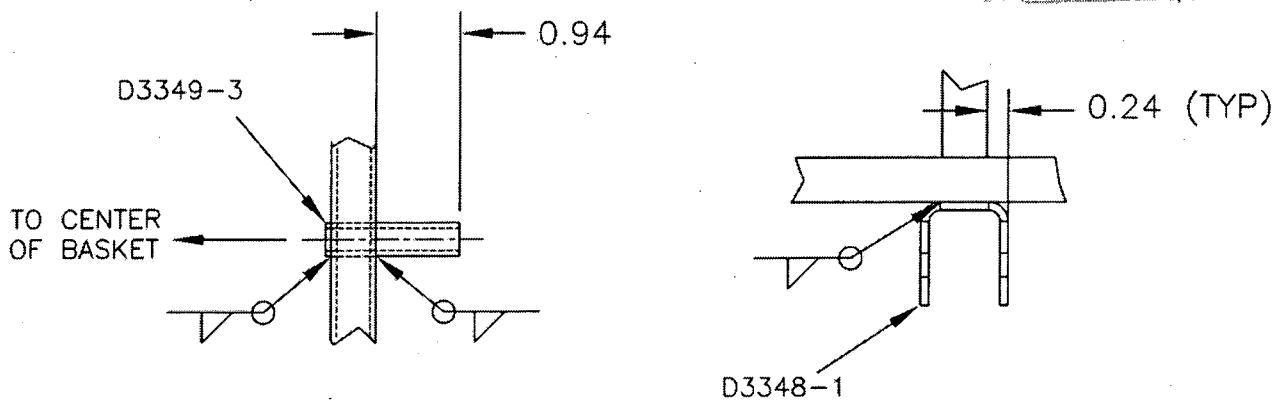
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8

D3328-3
HINGE PLATE
(TYP BOTH ENDS)



VIEW A-A

RELEASED
05.03.05



DETAIL B
(SCALE 1:2)

ph 06.06.18
UNDER REVIEW
05.03.05

DETAIL C
(SCALE 1:2)

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